

Work Order ID 86920

July-09-12 11:04:15 AM

303 121.0

86920

Page 1

Item ID: D3176-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 7/06/12

Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/06/12

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: ML3

Date: 12/07/10 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3176	Rev A								
100	Hardinge CNC LATHE SMALL	0.00				8	0		DA 13 89
100	Memo	0.00							
Hardinge	1-Turn as per Folio FA286 & DWG D31762-Debur								
Hardinge CNC Lathe Small									
110	QC2- Inspect parts off machine FAI/FAIB	0.00				8	0		DA 13 89
110	Memo	0.00							
QC									
Quality Control									
120	CONVENTIONAL MILLING MACHINE	0.00							
120	Memo	0.00							
Mill Conv	1- Mill Flats as per dwg D3176 2- Debur								
Conventional Milling Machine									

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86920

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

0.00

Quality Control

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 032

0.00

150

Packaging

Memo

0.00

Packaging

13/03/08

8

8

4/3/12

8

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Cust Item ID:

Required Date: 7/06/12 **Req'd Qty:** 8.00 ***Q***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject Qty

**Reject
Number**

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

11B-03-12

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Picklist Print

July-09-12 11:04:15 AM

Page 1

Work Order ID: 86920

Parent Item: D3176-1

Parent Item Name: Bushing

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:B Removed -3 05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303R1.000		Purchased	No			100	f	5.9822	0.31	2.6105264			
303 Round Bar 1.00													

Location	Loc Qty	Loc Code
MAT028	5.982157895	
120866	0.7	
121070	3.31515789	
121282	0.45	
121728	1.517	

124711

2.6 ft

13-3-13 (DAS 13 8-89)

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	86920
Description: Bushing		Part Number:	D3176-1
Inspection Dwg: D3176	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.990	+/-0.010	.991	/		SA-4	Ver
Ø0.472	+0.010/-0.000	.476	/			
3.716	+/-0.010	3.713	/			
0.130	+/-0.010	.125	/			
0.277	+/-0.010	.280	/			
0.550	+/-0.010	.550	/			
0.839	+/-0.010	.845	/			
0.745	+0.005/-0.000	.747	/			
0.625	+/-0.010	.620	/			
5/8-UNF18-3B	N/A	N/A	/			
.865	±.010	.8625	/			
Major Ø .6333/.6335						
Major Ø	M. ~ Max .6163/.6250	.620	/		SA-5	M.c
M.O.W	.6333/.6368	.6347	/		SA-5	M.c

Measured by: DAS 13 9-89	Audited by: DAS 14 9-89	Prototype Approval:	N/A
Date: 13-3-8	Date: 13/03/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue	KJ/RF	
B	06.03.09	Added 5/8-UNF18-3B	KJ/JLM	

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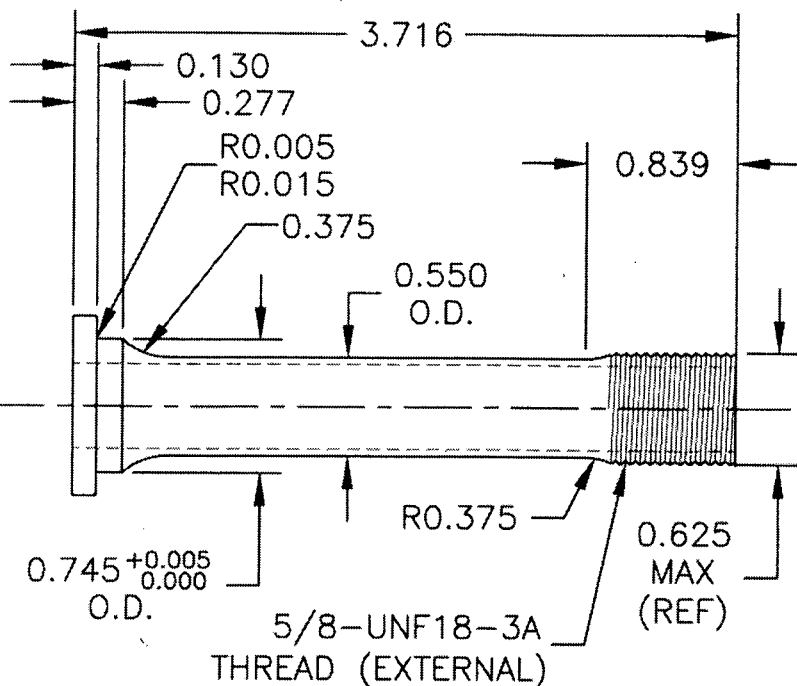
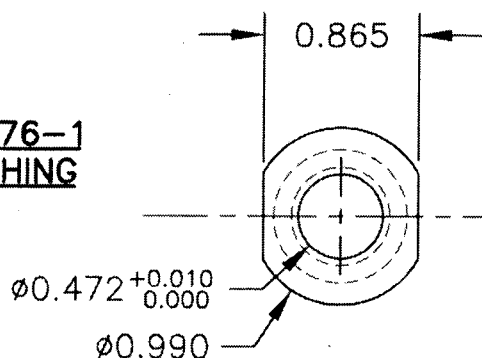
NOTE: Date & initial all entries



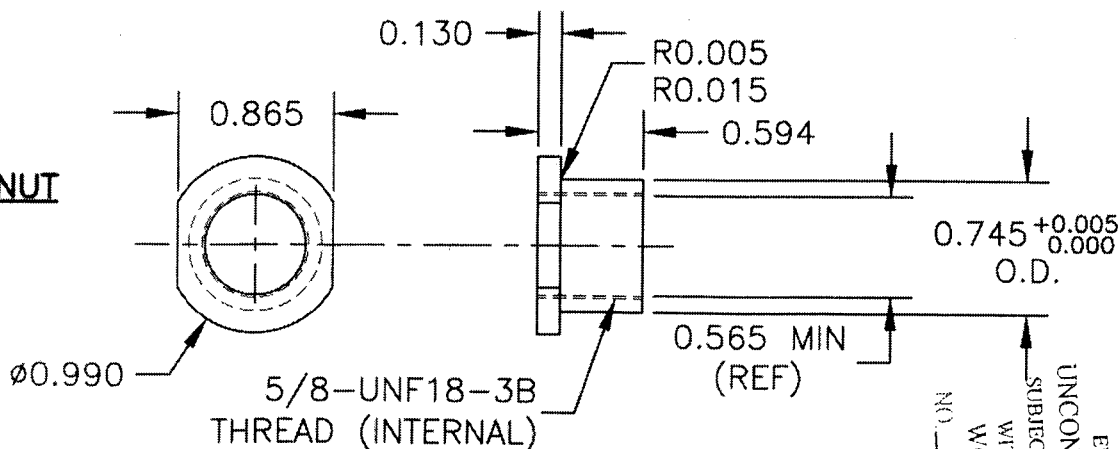
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3176	REV. A SHEET 1 OF 1
DATE 02.10.28		TITLE BUSHING / NUT	SCALE 1:1
A	02.10.28	NEW ISSUE	

RELEASED
02.10.31

D3176-1
BUSHING



D3176-3 NUT



D3176-1/-3

- 1) MATERIAL: AISI 303 S.S. (REF DART SPEC. M303R1.000)
2) THREADS PER MIL-S-7742
3) BREAK ALL SHARP EDGES 0.005 TO 0.015
4) FINISH: NONE
5) ALL DIMENSIONS ARE IN INCHES
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7) D3176-1/-3 ARE MATING PARTS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 8109222 *MCJ*
12/07/10

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